Work Orde Thursday, Septem												Page 1
Revision ID:	D3766-3 Rear Rail			Accept					Setup	Start Stop	1 100111101	11 (5) (4) (5) 11 (1) (1) (5)
Start Date: Required Date:	9/30/2010	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item Customer					į	! 	#10
Approvals:	Process Pla	n:	Date: 10-9-30) Date:	Tooling: SPC (Y/N):		Date:			Run	Start Stop		
Sequence ID/ Work Center ID)	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr		ision Nbr						The				
D3766 100 Small Fab Small Fab	Rev	Small Fab	be to lenght as per dwg D3766 166 using DT9413 ,Drill holes I	0.00 0.00 12-drill holes thru to fin labelled #3. □3- deburr	hish size as per	m.L	10/	1/10/1	<u>/</u> 3			<u>. </u>
QC Quality Control		QC5- Inspect part cor	mpleteness to step on W/O	0.00	why			47	<u>)</u> –			Pro
120 HandFinish Hand Finishing		Chemical Conversion Memo	n Coat per QS1005 4.1	0.00 BR 0.00	10-10-14	4		4	<u></u>			

Dart A	Aeros	pace	Ltd
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P PRO	CEDURE CHANGE	Ву	D		Approval	
	PROCEDURE CHANGE		Date	Qty	Chief Eng / Prod Mgr	Approval QC Inspector
						uga-
-						

Part No: _	D3766-3	_ PAR #:	Fault Category:	Small Fob	NCR: Yes No	DQA:	Date:	1010.13
	Pasalution:	SCHAO	Disposition: (~ ~ ^	OA: N/C Closed	. HE	Data	n hali

NCR: 62	2486	WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B		Verification	Approval	Approval					
DATE STEP		Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector					
शीवावि	# 100	-one part scrap. com holes Do not allign with the earlier ofte side. P.L. Process Tooling.	1	- Scrop + Dectry + Replace ah +1 m 114809	M-L 10/10/13	\sim		S					
	(00	P.L. Process Tooling.	6051042	ah +1 m 114809		10/10/14	/WS/UYZ,	10/0/13.					
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Page 2

Item ID:

D3766-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Rear Rail

Start Date: 9/30/2010 Start Qty: 4.00

Required Date: 10/8/2010

Req'd Qty: 4.00



Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling: SPC (Y/N): Date:

Tool ID

Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

130

140

Operation Description

QC3- Inspect Part Finish

Memo

Memo

Set Up/ **Run Hours**

Tool # Plan Code

Accept Qty

Reject Qty

Insp. Reject Number Stamp

Quality Control

Identify as per dwg & Stock Location: 25

0.00

0.00

Packaging

Packaging

QC21- Final Inspection - Work Order Release

0.00

150

Quality Control

Memo

0.00

10/10/18/10-18

W/O:			, WO	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C Cld	osed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Picklist Print

Thursday, September 30, 2010 2:23:05 PM

Work Order ID: 62486

D3766-3 Parent Item:

Parent Item Name:

Rear Rail



Start Date: 9/30/2010

Required Date: 10/8/2010

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC IPP Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	41.9539	2.7927	11.7587	m-f	15/.	10/12
				Location		Loc C	Qt <u>y</u>	Loc Code					
				MAT		1.2	2163				_		
					114520	1.2	2163		_				
				MAT016		40.737	7628				_		
					113511	3.75	5726				_		

36.980368

MI15868

114089

11-75874

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date:	
	Re	esolution:						Date: _	
NCR:		'	WORK ORE	DER NON-CONFORMA	ANCE (NCF	₹)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	ion B		cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	* Sect	ion C	Chief Eng	QC Inspector
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				- A - M - M - M - M - M - M - M - M - M					

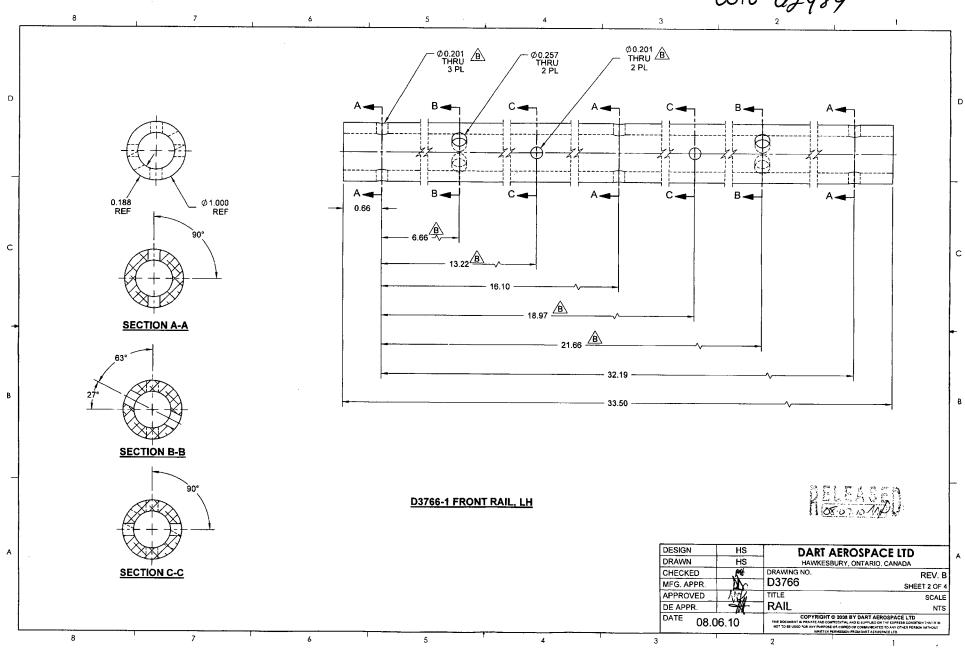
SHOP COPY RETURN TO ENGINEER, "G UNCONTRULED COST SUBJECT TO AMEND 105-41 WITHOUT MODICE Ð D3766-1 FRONT RAIL, LH D3766-2 FRONT RAIL, RH D3766-3 REAR RAIL CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125 HS 08.06.10 A NEW ISSUE 08.06.04 HS NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-220/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188) REV. DESCRIPTION BY DATE DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs DRAWING NO. CHECKED REV. B D3766 MFG. APPR. SHEET 1 OF 4 TITLE APPROVED SCALE RAIL DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD

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NOT TO BE USED FOR ANY PURPOSE OF COMPLEX COMMUNICATION OF ANY PURPOSE PROPERTY OF THE PURPOSE PURPOSE PROPERTY OF THE PURPOSE DATE 08.06.10 2

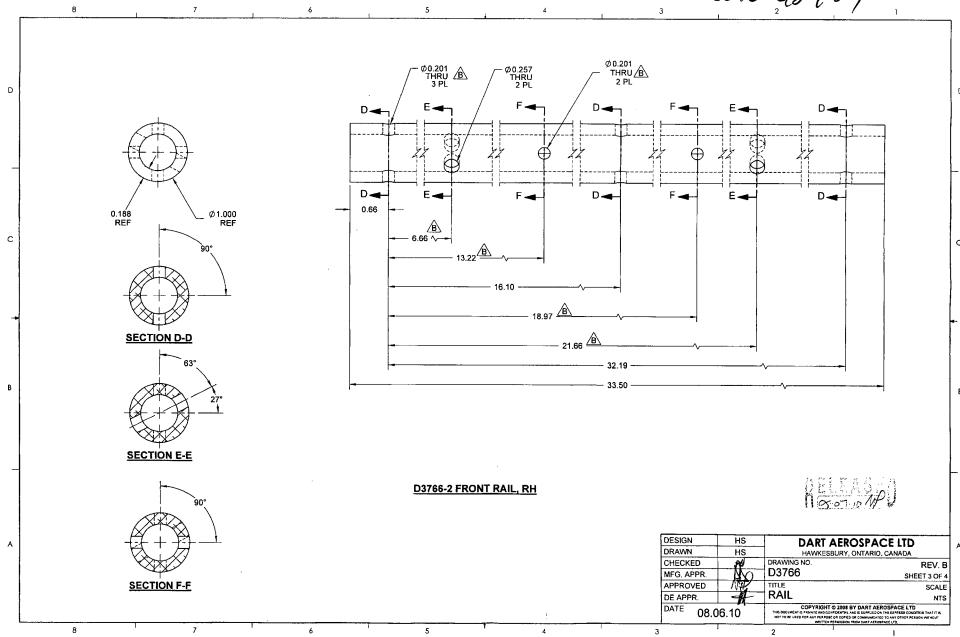
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NCR:		,	WORK OR	DER NON-CONFORMA	ANCE (NO	CR)		90 Apr - Accusant 10	
DATE	STEP	Description of NC		Corrective Action Section		Vei	rification	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n& ∣ _S	ection C	Chief Eng	QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA:	Date: _	
		solution:		•				
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DATE	CTED	Description of NC		Corrective Action Secti		Verificat	ion Approval	Approval
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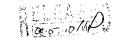


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DATE	STEP	Description of NC		Corrective A			Verifi	cation	Approval	Approval
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w/o 62486 161 Ø0.323 THRU 4 PL Ø0.201 THRU <u>B</u> 2 PL \oplus 11.15 — 9.22 <u>®</u>√ Ø1.000 REF 0.188 REF 1.808 1.6.72 - 24.22 1 26.19 3154 33.50

D3766-3 REAR RAIL



DESIGN	HS	DART AERO	CDACEITO		
DRAWN	HS	HAWKESBURY, ON			
CHECKED	₽¥	DRAWING NO.	REV. B		
MFG. APPR.	<i>II</i>	D3766	SHEET 4 OF 4		
APPROVED		TITLE	SCALE		
DE APPR.		RAIL	NTS		
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DATE	STEP	Description of NC Section A	Corrective Action Sect Initial Action Description Chief Eng Chief En		Section B	Sign &	Verification Section C		Approval Chief Eng	Approval QC Inspector
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